

Date: Tuesday, 16/09/2008 3:28:29 PM
 User: Julie Lecocq

Process Sheet

split

Customer	CU-DAR001 Dart Helicopters Services				Drawing Name	TOP PANNEL ASS'Y	
Job Number	42039 →				Part Number	D3650041	
Estimate Number	13067				Drawing Number	D3650 REV.B	
P.O. Number	:				Project Number	N/A	
This Issue	16/09/2008	S.O. No.	:		Drawing Revision	B	
Prsht Rev.	NC				Material	:	
First Issue	/ /	Type	:	SMALL /MED FAB	Due Date	30/10/2008	Qty: <i>2</i> Um: Each
Previous Run	39930						
Written By	:						
Checked & Approved By	<i>JUL 08.9.16</i>						
Comment	Est Rev:A New Issue 07-11-12 EC verified by: DD Est Rev:B Ecn 1113P 08-01-22 DD verified by:EC Est Rev:C Ecn1162 08-04-02 DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 pick kit	
2.0	D36501	Aft Panel	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) AFT PANEL batch <i>B42094</i>	<i>SB</i>
3.0	D36503	Center Panel	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) CENTER PANEL batch <i>B39933</i>	<i>SB</i>
4.0	D36505	Fwd Panel	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) CENTER PANEL batch <i>B42094</i>	<i>SB</i>
5.0	AN3C3A	Bolt	
		Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s) Bolt batch <i>M109297</i>	<i>SB 08/16/02</i> <i>(2)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/09/2008 3:28:29 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP PANNEL ASS'Y

Job Number: 42039

Part Number: D3650041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 AN960C10

WASHER



Comment: Qty.: 8.0000 EACH(s)/Unit Total : 40.0000 EACH(s)

WASHER

batch_M109148

SP 08/10/02 ②

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1-Assemble as per dwg D3650

2- Seal all mating surfaces and all gaps using Proseal 700 fire wall sealant
as per dwg D3650

Batch: M109415

FF 08/10/02 ②

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 08/10/02 ②

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: GR

SP 08/10/02 ②

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/03 ff

Job Completion



10/10/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

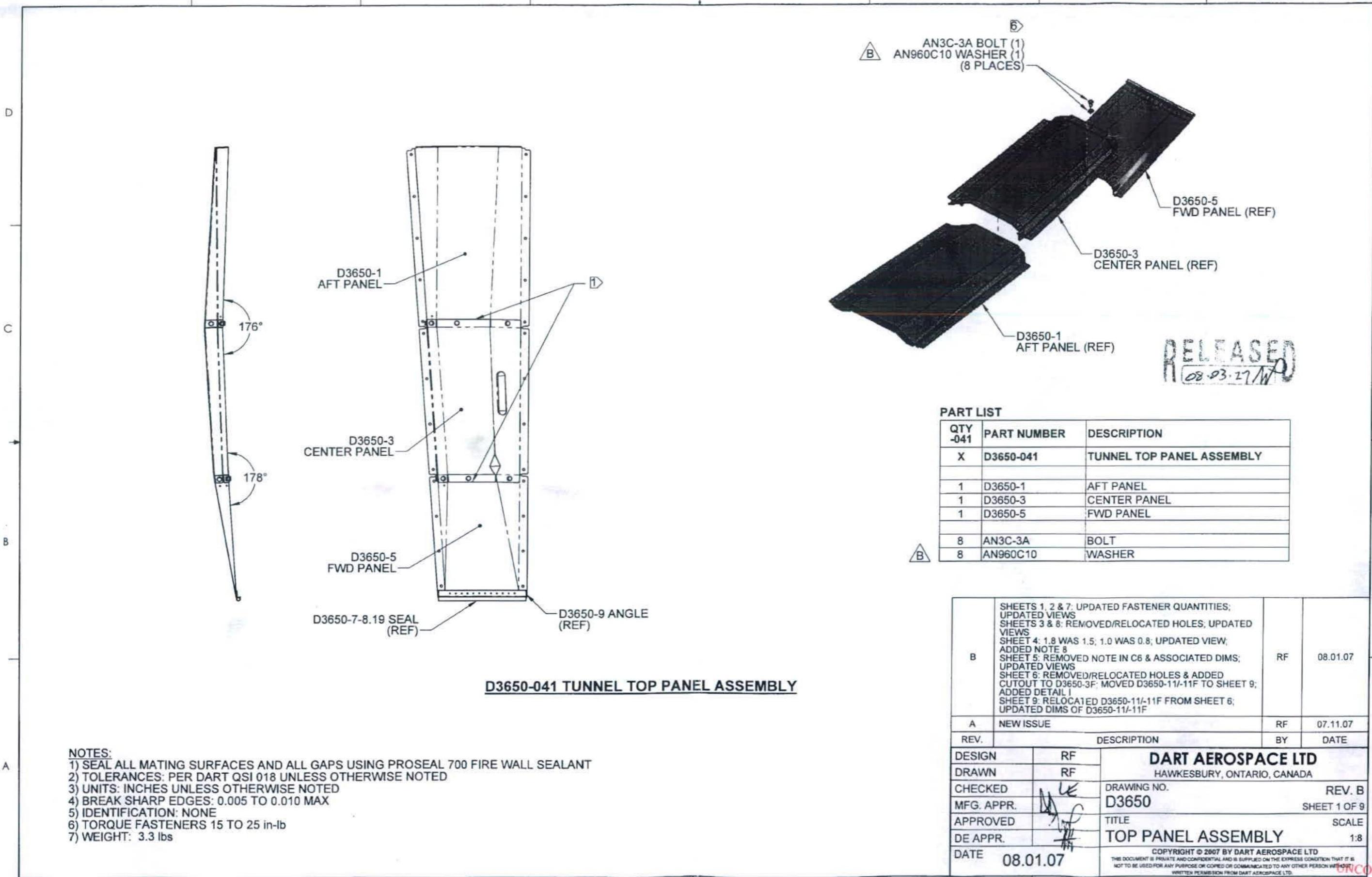
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

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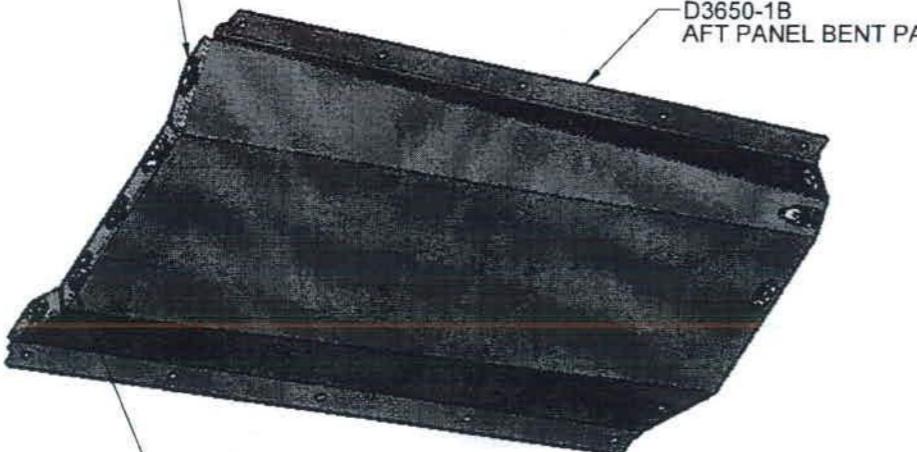
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NO. 42039



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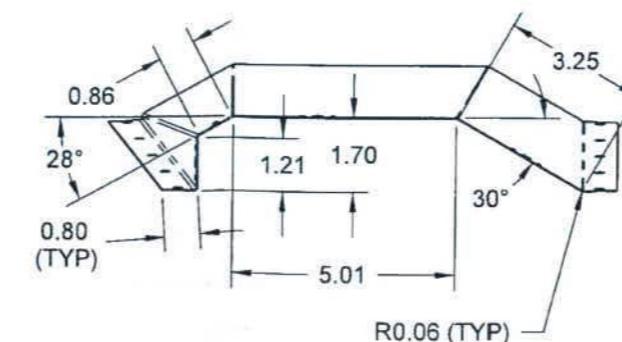
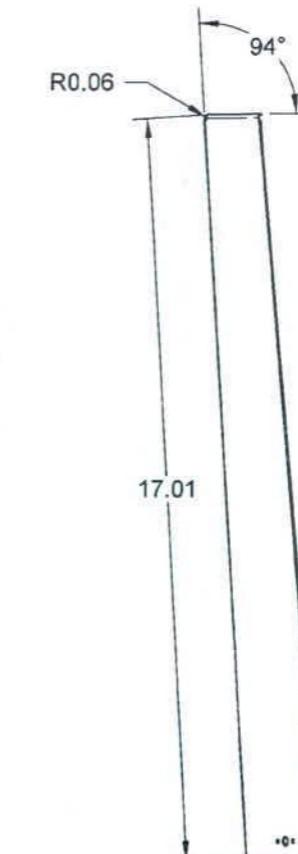
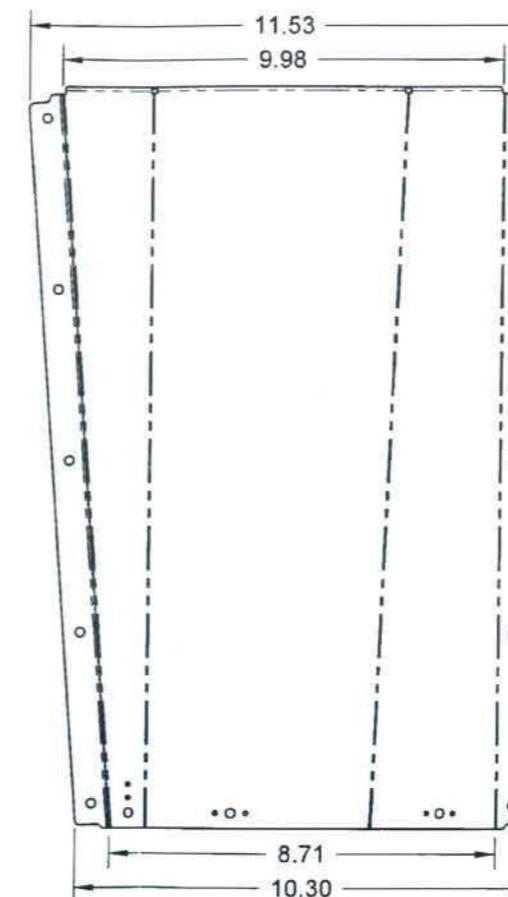
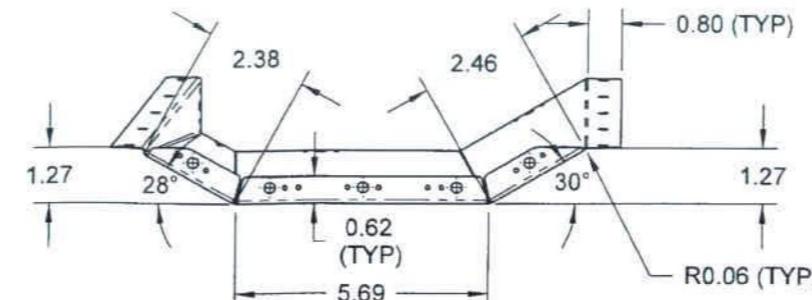
D

MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(6 PLACES)**D3650-1 AFT PANEL****PART LIST**

QTY -1	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE



- NOTES:**
- 1) FINISH: NONE
 - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 5) IDENTIFICATION: NONE
 - 6) WEIGHT: 1.3 lbs

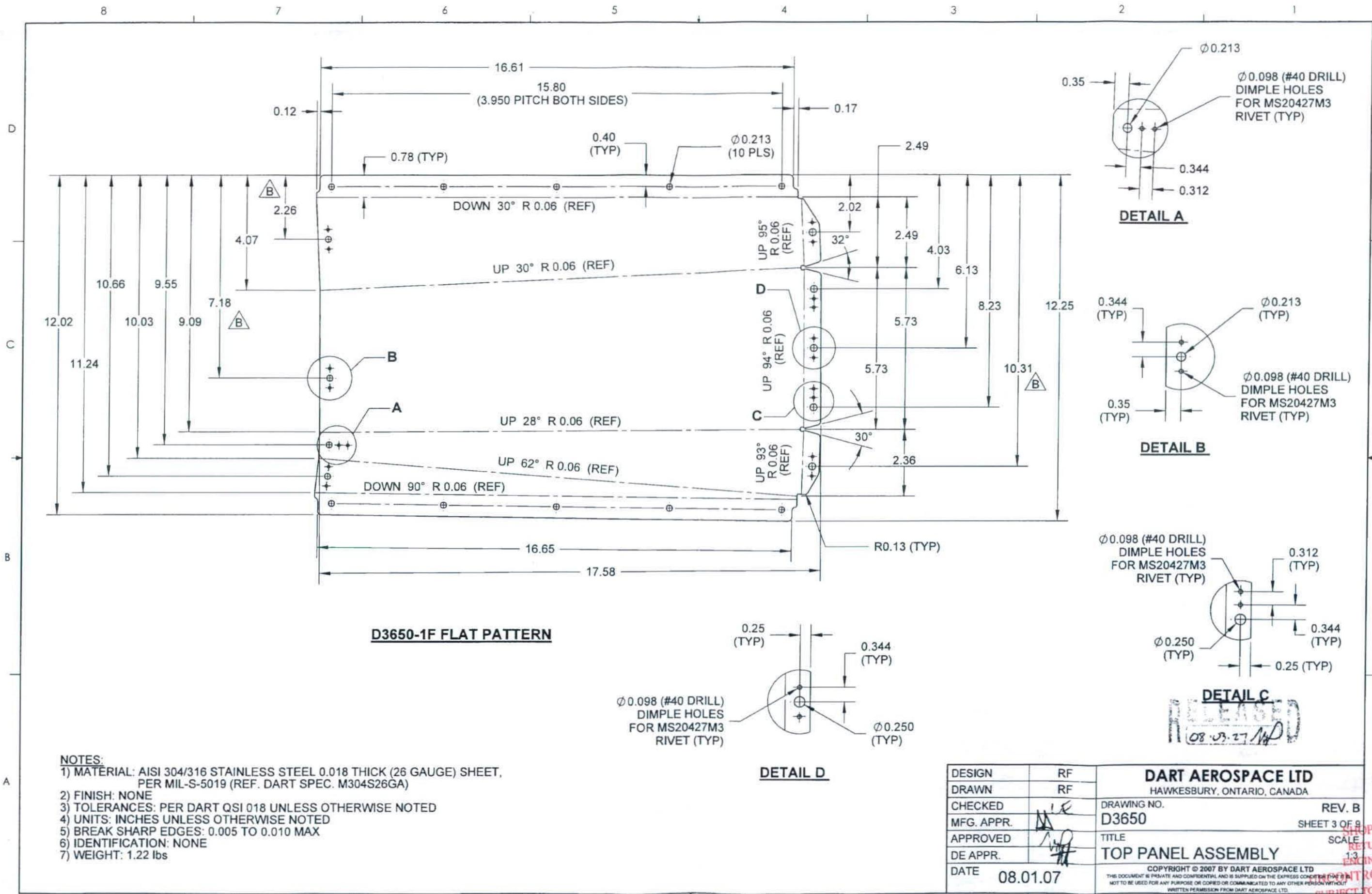
**D3650-1B AFT PANEL BENT PART**
(MAKE FROM D3650-1F FLAT PATTERN)

RELEASED
08-03-27 MR

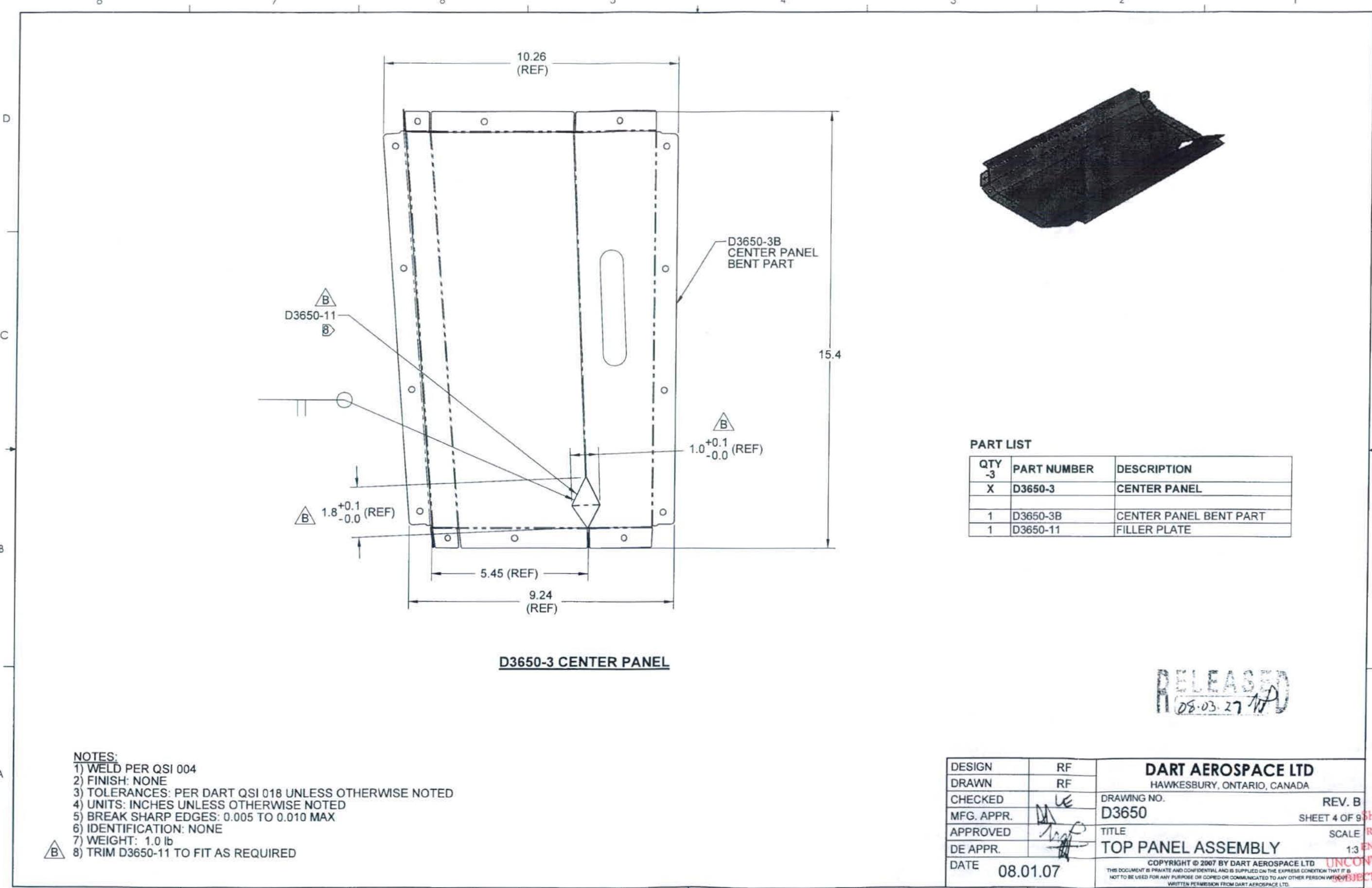
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	u	
MFG. APPR.	AA	
APPROVED	MM	
DE APPR.	MM	
DATE	08.01.07	REV. B SHEET 2 OF 9 TITLE TOP PANEL ASSEMBLY SCALE 1:4 COPYSPEC RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO 40039

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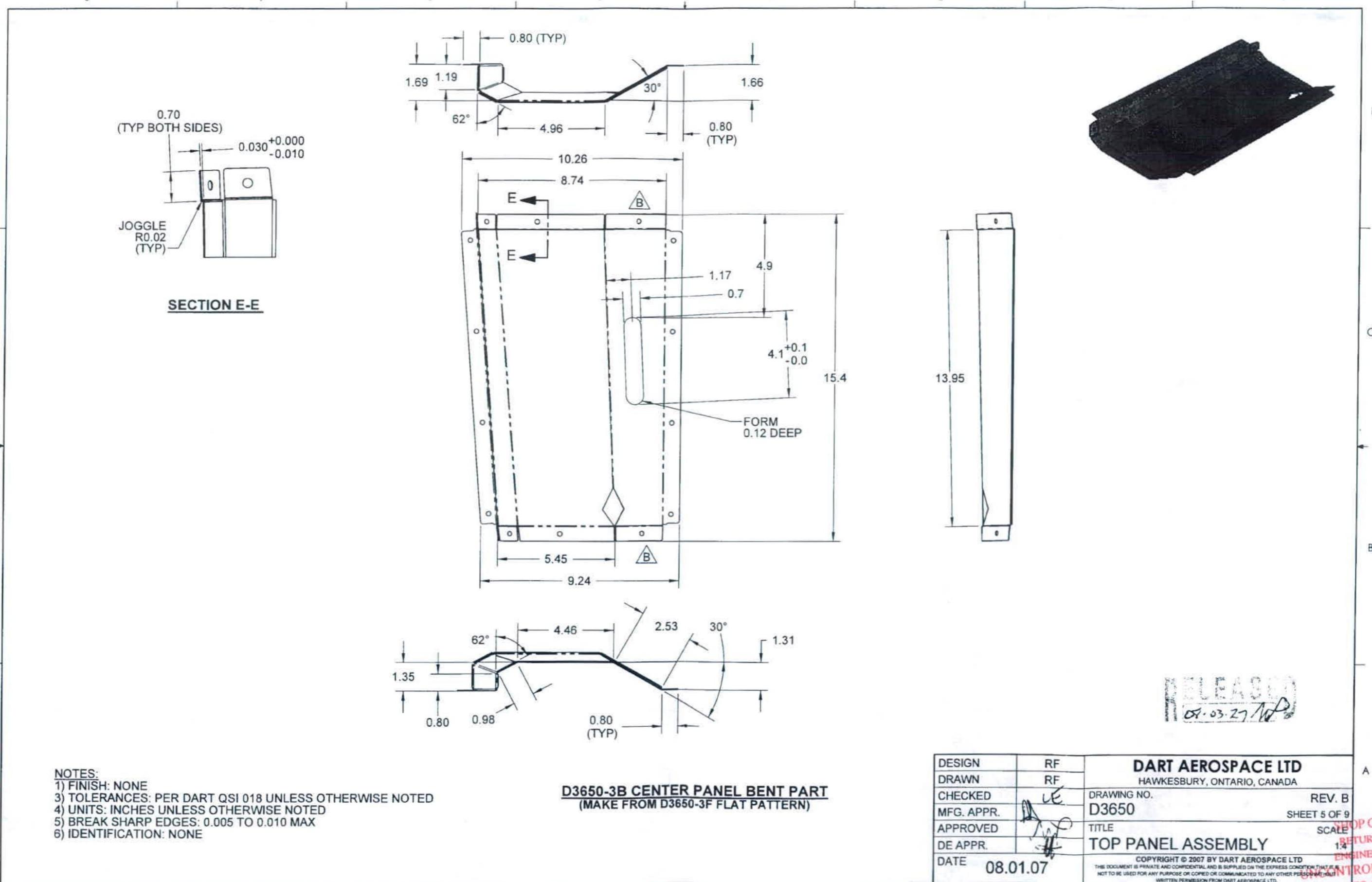




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CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MA	D3650	SHEET 4 OF 9
APPROVED	MF	TITLE	SCALE
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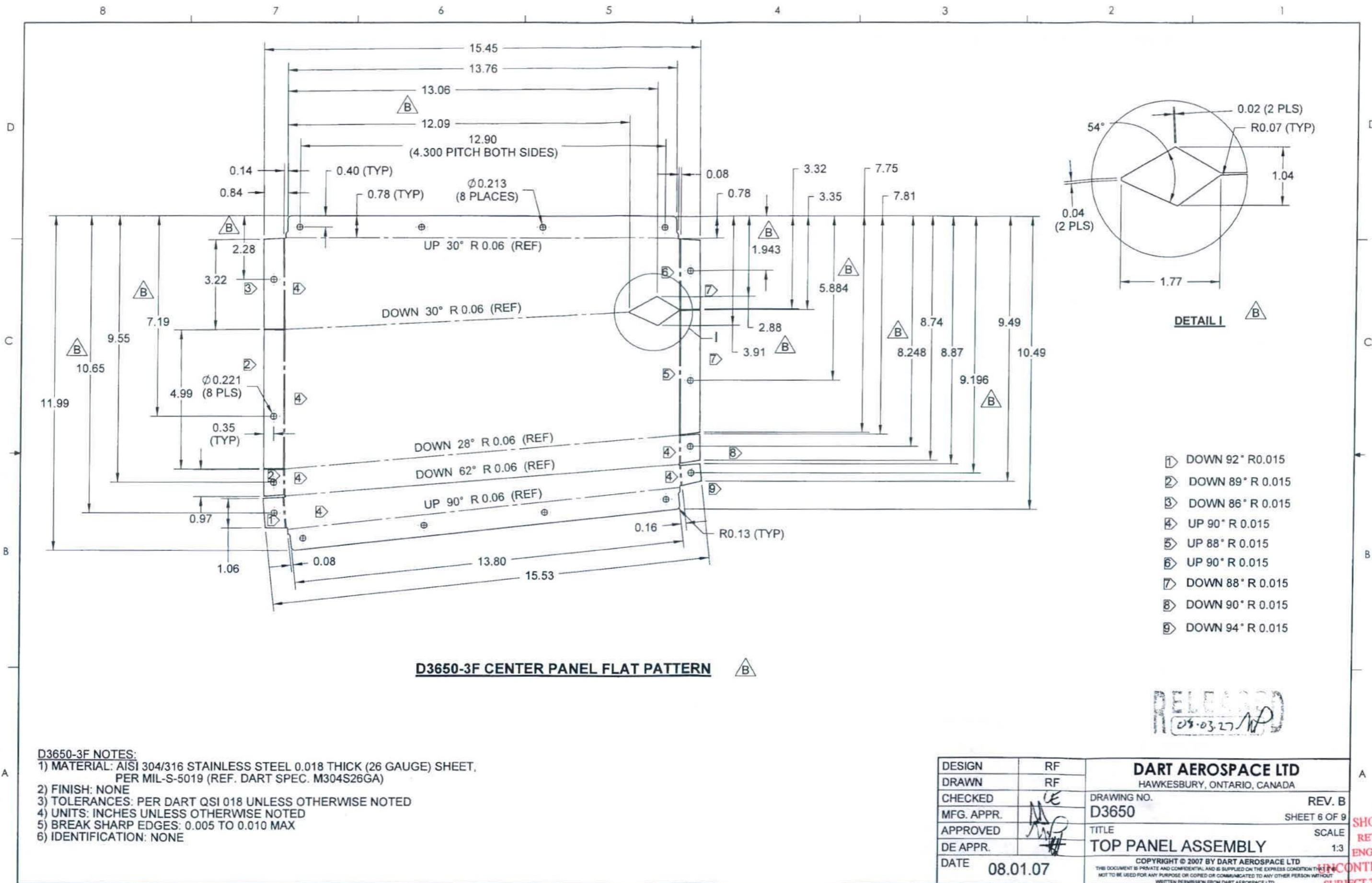
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MFG. APPR.		REV. B
APPROVED		D3650
DE APPR.		SHEET 5 OF 9
DATE	08.01.07	SCALE

TOP PANEL ASSEMBLY

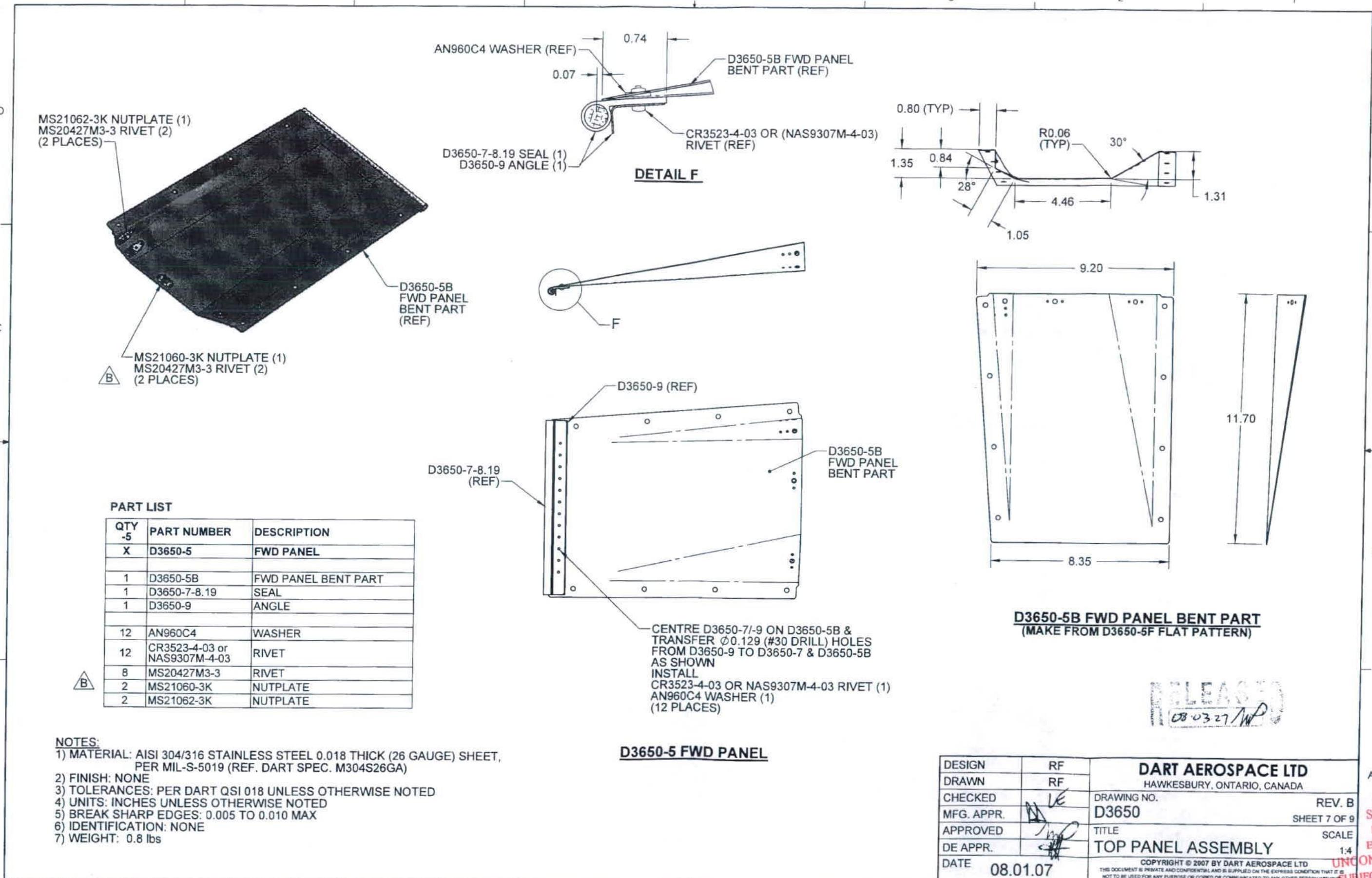
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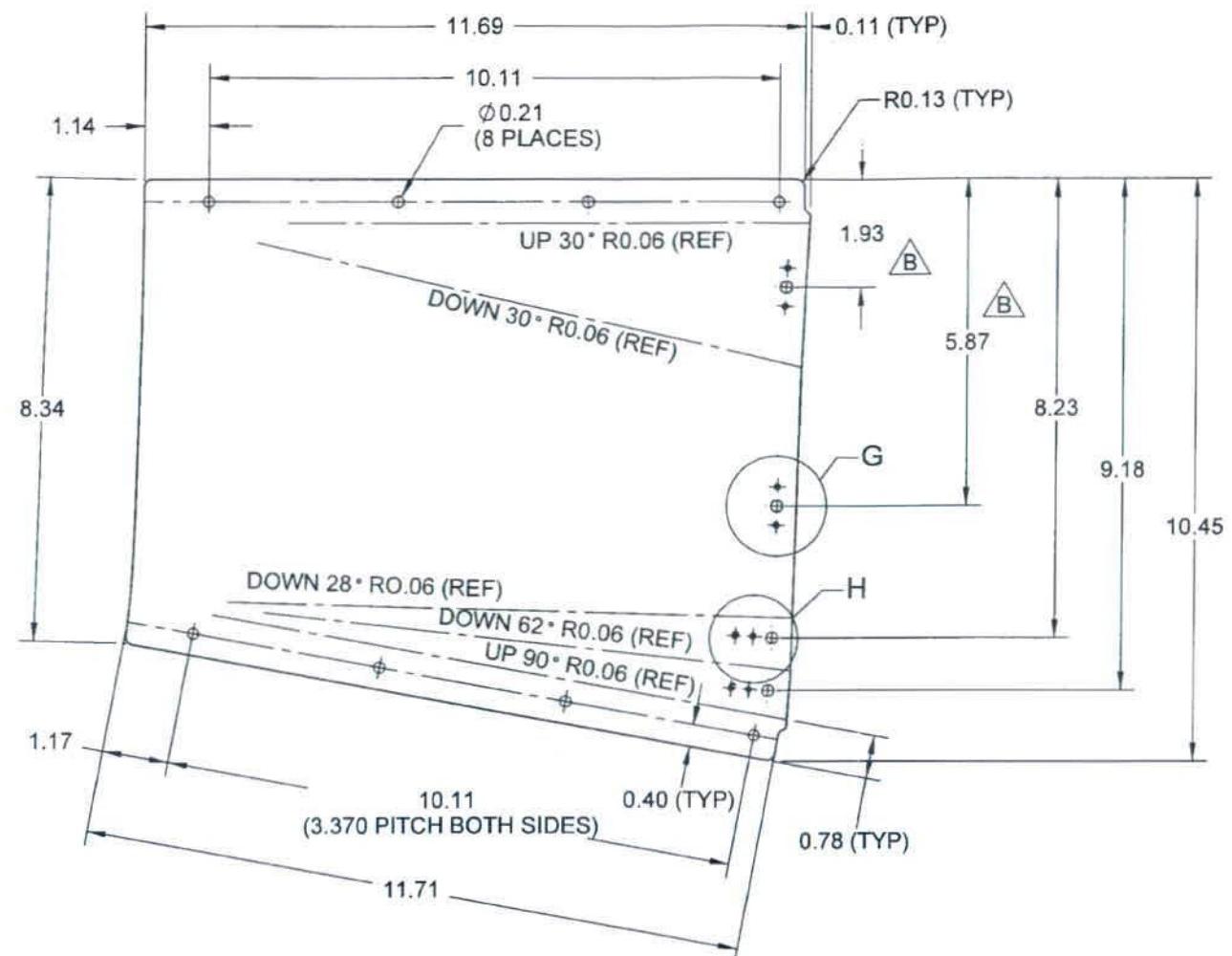


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CHECKED	LE	DRAWING NO. D3650
MFG. APPR.	W	
APPROVED	TMC	REV. B SHEET 7 OF 9
DE APPR.	W	
DATE	08.01.07	TITLE TOP PANEL ASSEMBLY

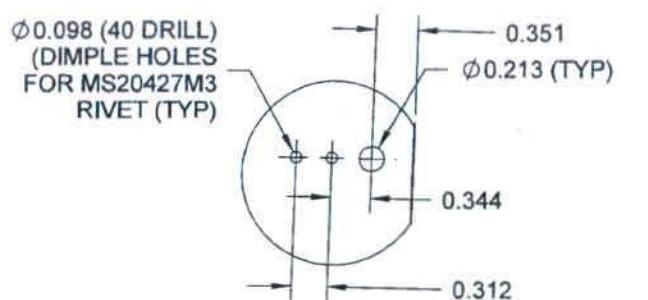
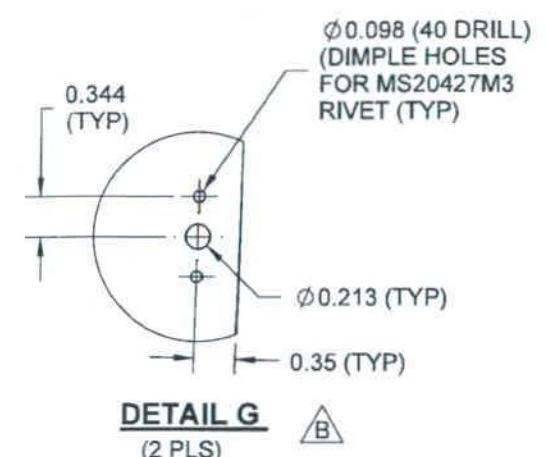
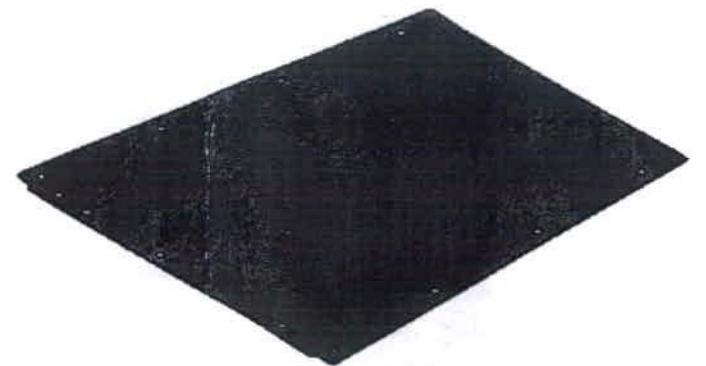
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D3650-5F FLAT PATTERN



NOTES

- NOTES:**

 - 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.6 lb

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3650	SHEET 8 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TOP PANEL ASSEMBLY	1:3
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